

green

3

Date: Wednesday, 11/21/2007 12:47:33 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT
Job Number : 35914	
Estimate Number : 10532	
P.O. Number : N/A	Part Number : K10003
This Issue : 11/21/2007 S.O. No. : N/A	Drawing Number : IIN D205-634 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : D
Previous Run : 34810	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 1/15/2008
Checked & Approved By : <u>[Signature]</u>	Qty: 12 Um: Each
Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 JLM Est : K 06.11.17 Per K10003 Rev C KJ Est Rev: L 07.01.12 Document Record for copying bluefile rmv KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 005

08/06/02

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2570	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 288.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	35130

08/01/03

4.0	D2571	Saddle, Fwd, Out
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	35915

08/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 35914

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty
1

Part Number
D2572

Description
Saddle

Batch

35916 green

AS 08/01/09 (12)

6.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty
1

Part Number
D2573

Description
Saddle

Batch

35917 green

AS (12)

7.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Saddle, Aft, In

Pick:

Qty
1

Part Number
D2574

Description
Saddle

Batch

35918 green

AS (12)

8.0

D27361

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Lug Assembly

Pick:

Qty
1

Part Number
D2736-1

Description
Bracket

Batch

31816

AS (12)

9.0

D27363

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Lug Assembly

Pick:

Qty
1

Part Number
D2736-3

Description
Bracket

Batch

33566

AS 08/01/09 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:33 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 35914

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 48.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B33470 x38 B35758 x10

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B29789 x13 B33543 x11

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	32124

13.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	B30274

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Set Screw

Batch:

B328093

15.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bolt

Pick:

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:33 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 35914

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation:

Description: there was 35 same batch

Qty 16 Part Number AN4-6A Description Bolt

Batch

M104322 (x35) M1006662 x157

16.0 AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Bolt

Pick:

Qty 4 Part Number AN4-46A Description Bolt

Batch

M104975

17.0 AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 96.0000 Each(s)

Bolt

Pick:

Qty 8 Part Number AN4-51A Description Bolt

Batch

M105810

18.0 AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 96.0000 Each(s)

Bolt

Pick:

Qty 8 Part Number AN6-12A Description Bolt

Batch

M105558

19.0 AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total: 384.0000 Each(s)

Washer

Pick:

Qty 32 Part Number AN960JD416 Description Washer

Batch

M105906

20.0 AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 96.0000 Each(s)

Washer

Pick:

Qty 8 Part Number AN960JD616 Description Washer

Batch

M105906

AS 08/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LD Date: 29/01/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:47:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 35914

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

Pick:

Qty Part Number Description Batch
1 AN970-4 Washer

M105442

AS

(12)

22.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 348.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
29 MS21042L4 Nut (or MS21042-4)

M105054

AS 08/01/03

(12)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

08/01/09 (12/1/09)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: R.P.K.

AS

08/01/09

(12)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/01/11

Job Completion



08-01-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13 #

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING
SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION	SHOP COPY
BELL 205/210/212/412	D205-634-011 D205-634-015	RETURN TO ENGINEERING
BELL 204	D204-635-011	UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 35914

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE
FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

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